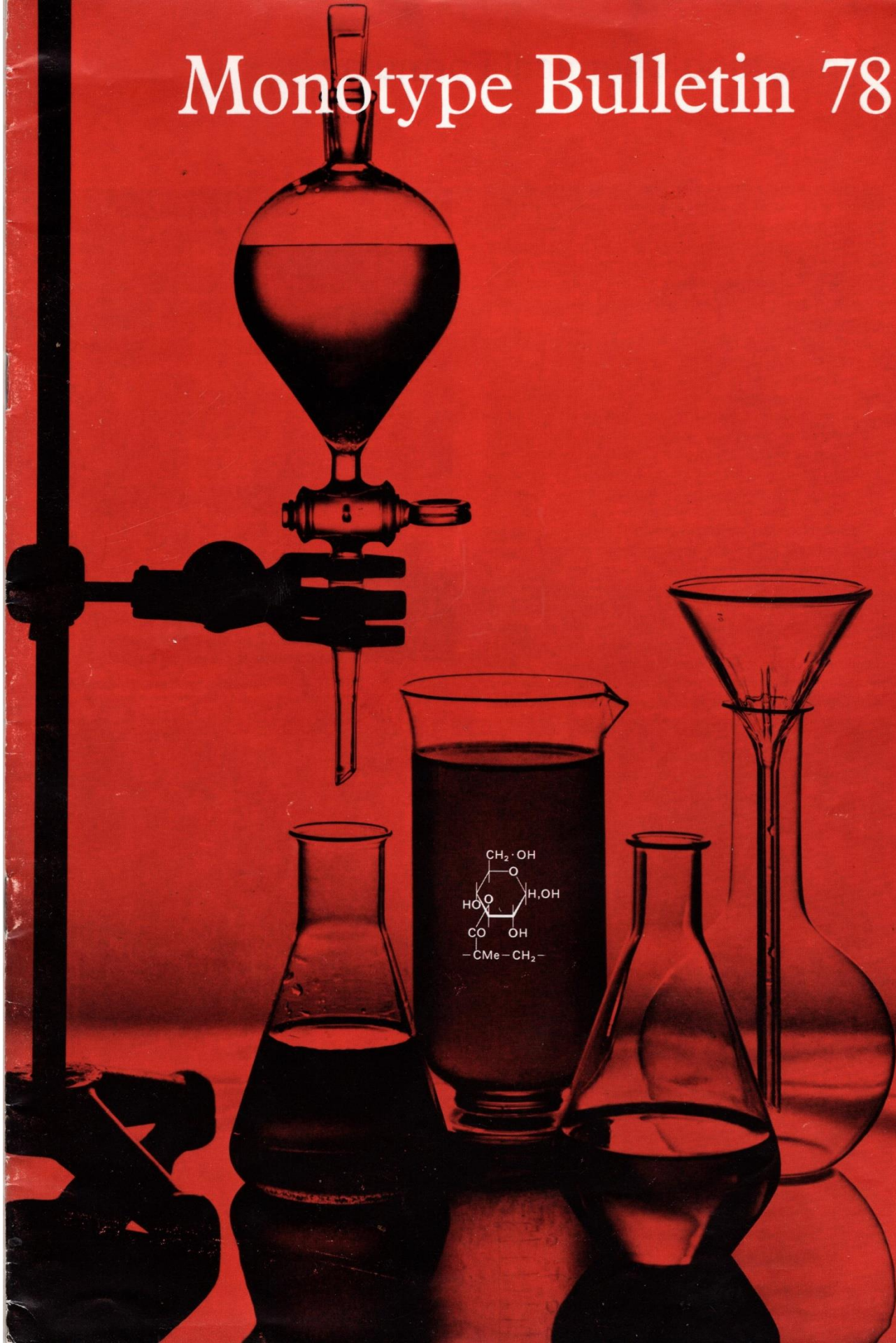


Monotype Bulletin 78



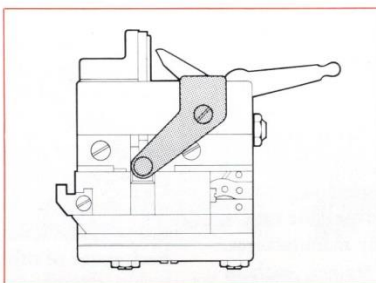


Casting spaces on the Super caster

A fact which has received little publicity in the past is that the space casting attachment normally associated with the composition caster can be used to cast spaces from a composition mould on the Type and Rule caster and the Super caster. This useful adjunct has recently been incorporated as a Super caster attachment (375U1).

The object is to avoid the necessity to use a blank matrix to hold down the upper mould blade when casting low spaces (or to seal the top of the mould for high spaces) when using the small-type composition moulds up to 14 point – and in consequence, there is no need to fit a matrix head.

The attachment plate is fitted to the mould as illustrated. All that need be done is to remove the mould cover screw (332), place the plate in position, and secure it with the longer screw ($\frac{3}{4} \times 1\frac{1}{8}$) provided with the attachment. The forward end of the bracket has a clamp which is seated over the casting cavity, being positioned on the mould by means of a knurled adjusting screw, and secured with a lock-nut. The low quad lever of the adaptor base is attached to the mould blade compensating lever as normal for high or low spaces as required.



Before finally fixing the attachment to the mould, take particular care to ensure there is clearance for the type carrier when it is in the right-hand position (receiving type from the mould).

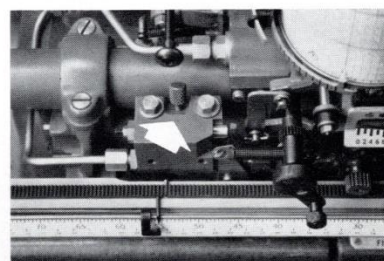
Unit wheel locking bolt

Some users of keyboards for Mark 4 filmsetting have queried the function of the knurled-head bolt in the piston block of the unit wheel stop group. The answer is simple: it has no use relevant to this keyboard. It does, however, have a constructive purpose as far as hot-metal and Mark 2 and Mark 3 filmsetting keyboards are concerned.

The device was originally introduced for the combined spacing attachment for hot-metal composition. The design provides for adjustments to allow correct meshing of the locking teeth with those of the unit wheel.

The locking bolt was incorporated to allow normal operational conditions to be restored should the 0005 signal be required for any purpose other than combined spacing or double exposure: for example, if a Mark 2 or Mark 3 filmsetting keyboard is used for hot-metal setting and justification key reversing procedure is used, or a duplex mould signal is required.

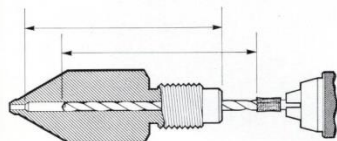
On Mark 4 filmsetting keyboards the bolt should not be disturbed but left in the 'out' position, as set during assembly.



NOZZLES AND DRILLS

A few years ago we printed (*in Technical Bulletin No. 51*) a table of pump-nozzle cleaning-drill data which we understand has proved useful over the years. We have now brought this table up to date and present it on this page. May we now repeat the cautionary note, given in *Bulletin No. 51*, for the benefit of younger readers and older ones who may not have saved that number?

When cleaning nozzles having two-stage bores, the drill for the lower, larger-diameter hole, if allowed to penetrate too far, will break through the tip of the nozzle. Therefore always be sure that the measurement between the tip of the drill and the depth stop is exactly that given in the right-hand column of the table.



Pump nozzles and drill data

Nozzle no.	Comp. caster symbol	Super caster symbol	Lower hole drill dia. ins.	Upper hole drill dia. ins.	Lower hole length ins.	Lower hole length mm
1	14H	12SH	.120	.062	$2\frac{3}{8}$	55.56
2	a14H2	12SH1	.120	.120	—	—
3	—	12SH6	.152	.062	$2\frac{5}{8}$	52.78
4	—	12SH2	.213	.213	—	—
5	—	12SH3	.302	.213	$2\frac{1}{4}$	53.97
6	—	12SH4	.120	.120	—	—
7	—	12SH7	.120	.120	—	—
8	—	12SH5	.120	.120	—	—
9	14H7	12SH14	.120	.029	$2\frac{5}{8}$	58.74
10	—	12SH11	.180	.062	$2\frac{1}{4}$	57.55
11	—	12SH13	.152	.082	$2\frac{5}{8}$	52.78
12	b14H	b12SH	.120	.062	$2\frac{3}{8}$	55.56
13	c14H2	a12SH1	.120	.120	—	—
14	a14H4	—	.120	.062	$2\frac{5}{8}$	52.78
15	14H32	—	.120	.062	—	—
16	c14H	c12SH	.093	.062	$2\frac{3}{8}$	55.56
17	d14H	d12SH	.093	.062	$2\frac{3}{8}$	55.56
23	a14H7	a12SH14	.120	.029	$2\frac{5}{8}$	58.74

Symbols for ordering drills

Dia. ins.	Dia. mm	Comp. caster	Super caster
.029	.73	4CT6	16ST8
.062	1.75	4CT3	16ST1
.082	2.08	—	16ST9
.093	2.36	a4CT2	16ST11
.120	3.05	b4CT2	16ST10
.152	3.86	—	16ST5
.180	4.75	—	16ST6
.213	5.40	—	16ST4
.302	7.67	—	16ST7



The Monotype Corporation Limited was one of the first recipients of The Queen's Award to Industry for achievements both in increasing exports and in technological innovations

The Monotype Corporation Limited

REGISTERED OFFICE: MONOTYPE HOUSE, 43 FETTER LANE, LONDON EC4
HEAD OFFICE & WORKS: SALFORDS, REDHILL, SURREY, ENGLAND

Registered Trade Marks: Monotype, Monophoto, Univers

Pictorial Machinery Limited

HEAD OFFICE & WORKS: KELVIN WAY, MANOR ROYAL, CRAWLEY, SUSSEX, ENGLAND

Registered Trade Marks: Lithotex, Lithoprintex

The Monotype group is represented by a world-wide sales/service organisation of branch offices, subsidiary companies, distributors and agencies at:

Algiers	Cairo	Kingston	Port of Spain
Allahabad	Calcutta	Kuala Lumpur	Quito
Amman	Cape Town	Lagos	Rangoon
Amsterdam	Caracas	Lahore	Reykjavik
Ankara	Casablanca	Lima	Rio de Janeiro
Athens	Chicago	Lisbon	Rome
Auckland	Christchurch	London	Santiago
Baghdad	Colombo	Los Angeles	San Francisco
Bangalore	Copenhagen	Luanda	São Paulo
Bangkok	Dacca	Madras	Singapore
Barcelona	Decatur	Madrid	Stockholm
Beirut	Djakarta	Manila	Sydney
Belgrade	Dublin	Melbourne	Teheran
Berlin	Dunfermline	Mexico City	Tel Aviv
~~Bombay~~	~~Frankfurt~~	~~Milan~~	~~Tokyo~~
Birmingham	Guatemala City	Nairobi	Toronto
Bogotá	Harrogate	New Delhi	Tunis
Bombay	Helsinki	New York	Turin
Boston	Hong Kong	Oporto	Valletta
Brisbane	Istanbul	Oslo	Vienna
Bristol	Johannesburg	Paris	Warsaw
Brussels	Karachi	Philadelphia	Zagreb

Monotype Bulletin is the quarterly service journal of The Monotype Corporation Limited and Pictorial Machinery Limited. Correspondence about it should be sent to Technical Literature Department, The Monotype Corporation Limited, Salfords, Redhill, Surrey, England.